

Work Order ID 66667

Wednesday, February 23, 2011 2:16:12 PM

Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 11-02-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

8/13/04CK by BG 11/03/04

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

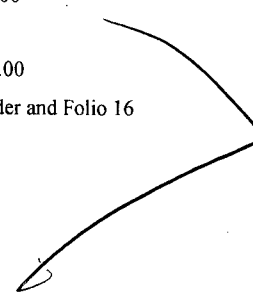
0.00

CNC Delta 100 Bender

-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

DP11-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

130

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

11-2-23

W/O:		WORK ORDER CHANGES					
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Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004
A/R□□□ Aluminum Rod

Mile 577

BE 11/02/28

2-Grind welds on step as per Dwg D2580

BE 11/02/28

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.

BE 11/02/28

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

> DP

11-3-1

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sulo 3/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(+0)			
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00				(1X)			
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951 Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00				(1X)			

⇒ m-L 11/03/03

m-L 11/03/03

11:00
3200F
11:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 21103103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of SikaFlex on insert holes before installing wearplates
A/R ☐ ☐ ☐ SikaFlex-291 ☐ 11116040
SikaFlex expire date: 11169

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with SikaFlex. Clean excess adhesive
A/R ☐ ☐ ☐ SikaFlex-291 ☐ 11116040
SikaFlex expire date: 11109

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 11116402

1 ~~0~~ 2 2/03/07

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D205-634-041

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/11/03/04



Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

11/13/08

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: 73

PPP Rev: 2

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00



11/03/04

ME

11-03-04

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, February 23, 2011 2:16:18 PM

Page 1

Work Order ID: 66667

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1

Manufactured

No

140

Each

166.0000

20

20



Spacer

Location

Loc Qty

Loc Code

LG

166

65529

166

110

Each

5.0000

1

1

D2580-1

Manufactured

No



205 Skidtube bent detail

Location

Loc Qty

Loc Code

ST046

5

59856

1

66095

2

66268

2

140

Each

52.0000

1

1

D2576-3

Manufactured

No



Step (maching detail)

Location

Loc Qty

Loc Code

LG

52

46661

4

52215

48

BE 11/02/28

DP 11-2-23

BE 11/02/28

DP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 66667

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

 Cap

Manufactured No

200 Each

42.0000 1 1



1103103

Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

41

50513

1

50770

28


51539

2

53791

10

✓

AN3-5A

 Bolt

Purchased No

200 Each

732.0000 2 2



1103103

Location

Loc Qty

Loc Code

ST350

732

115016

56


115371

500

116632

176

X2

AN960JD10L

 Washer

NAS1149D0332J Purchased

No

200 Each

6.0000 2 2



1103103

Location

Loc Qty

Loc Code

ST335

6

11912

6

M117010

X2

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Shop Packet Print

Page 2

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Page 3

Work Order ID: 66667

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,814.000

50

50



Insert



1103103

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1793

111529

32

113238

17

115502

500

115581

244

116800

1000

x50

AN3C4A

Purchased

No

200

Each

2,296.000

50

50



BOLT



1103103

Location

Loc Qty

Loc Code

ST350

2296

115300

25

116075

337

116704

734

116924

1200

x50

AN960C10L

NAS1149C0332

Purchased

No

200

Each

127.0000

50

50



washer



1103103

Location

Loc Qty

Loc Code

ST245

127

107534

59

108246

68

N11163041

x50

Wednesday, February 23, 2011 2:16:19 PM

Shop Packet Print

Page 3

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Page 4

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Parent Item Name: Replacement Skidtube

Start Date: 2/23/2011



Required Date: 3/11/2011

Start Qty: 1.00



Required Qty: 1.00

D3566-13 Manufactured No 200 Each 34.0000 1 1
 Gasket  24 1103103



Location	Loc Qty	Loc Code
FP014	34	
64070	17	X1
66137	17	

D3566-5 Manufactured No 200 Each 13.0000 1 1
 Gasket  24 1103102

Location	Loc Qty	Loc Code
FP015	13	
63574	1	
66146	12	X1

D3566-1 Manufactured No 200 Each 33.0000 2 2
 Gasket  24 1103103

Location	Loc Qty	Loc Code
FP015	33	
57715	1	
66040	20	
66129	12	X2

D3564-11 Manufactured No 200 Each 11.0000 1 1
 Wearshoe  24 1103103

Location	Loc Qty	Loc Code
FP019	11	
65159	11	X1

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Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200 Each

25.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP17

25

365522

59660

1

62229

2

66136

22

X1

D3564-9

Manufactured No

200 Each

4.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP

1

55334

1

FP19

3

62238

3

X1

D3564-5

Manufactured No

200 Each

19.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

16

63575

1

66148

15

365523

X1

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Parent Item Name: Replacement Skidtube

Start Date: 2/23/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No

200 Each

1,031.000

16

16



O-Ring, 205 Skidtube



16

4103102

Location

Loc Qty

Loc Code

FP

543

55546

19

58191

12

59358

12

65518

500

fpa

488

61762

488

D2594-1 Manufactured No

200 Each

327.0000

16

16



Plug, 205 Skidtube



16

4103103

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

144

58434

15

65980

129

16

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]***DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *[Signature]*
11-02-23

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28

DEO ATTACHED

Technical drawing of a circular component with the following callouts and dimensions:

- #0.208**: Dimension for the central hole.
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Instruction for drilling two locations.
- SEAL WITH SIKAFLEX-241/-291**: Instruction for sealing the component.
- AN3-SA BOLT (1)**: Callout for one bolt.
- AN960JD10L WASHER (1)**: Callout for one washer.
- (2 PLACES)**: Dimension for two locations.
- D2855 CAP**: Callout for the cap.
- 0.40**: Dimension for the outer radius.

Diagram illustrating the components of a wheel assembly:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)
- AFTER PERFORM:
 1. CHA
 2. INS
 3. WE
 4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

The diagram illustrates a road cross-section with a 4% grade and a 20.0' radius curve. The road surface is shown with a 1.4' offset from the centerline. The distance between the hole and the tangent point is 1.0'. The distance between the hole and the tangent point is 13.4'. The distance between the hole and the tangent point is 1.0'. The distance between the hole and the tangent point is 32.0 ± 1.0'.

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

D

P

P

P

P

P

P

P

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN96C10L WASHER (1)

(50 PLACES)

DESIGN

DRAWN BY

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DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>
DATE 07.02.27			

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

	DRAWING NO.
--	-------------

D2580

TIME	
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205 514

REV. D

SHEET 2 OF 3

SCALE

ASSEMBLY

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

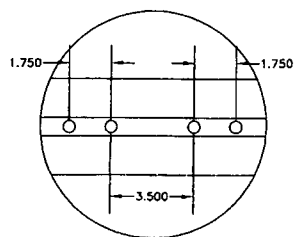
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

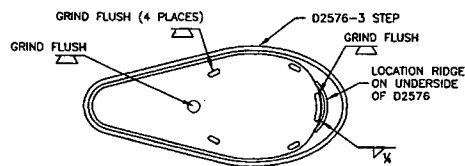
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24



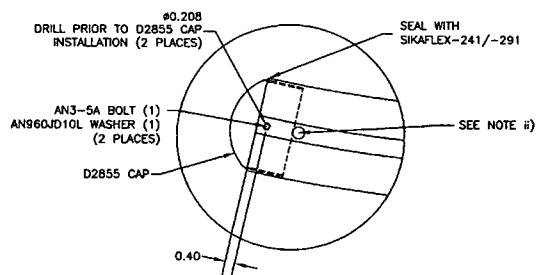
RELEASED
07-06-18

DETAIL F
SCALE 5:24

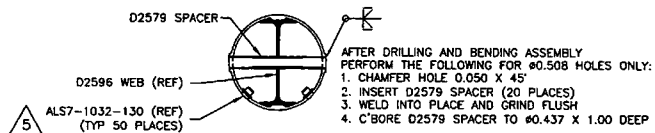


DEO ATTACHED

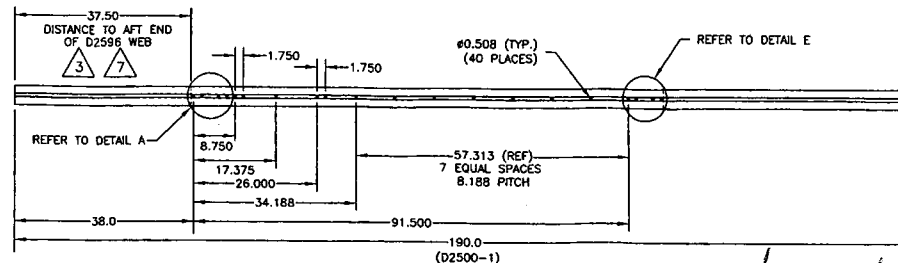
DETAIL G
SCALE 5:24



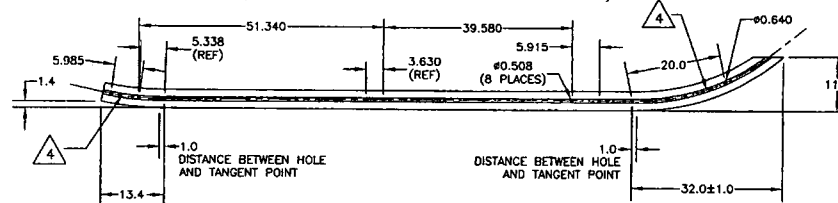
SECTION H-H
SCALE 5:24



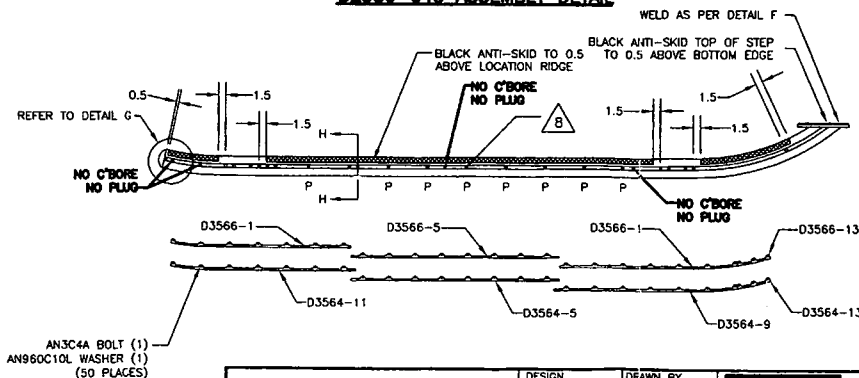
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED <i>RH</i>	APPROVED <i>RH</i>	DRAWING NO. D2580	REV. D
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SHEET 3 OF 3	SCALE 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>B</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

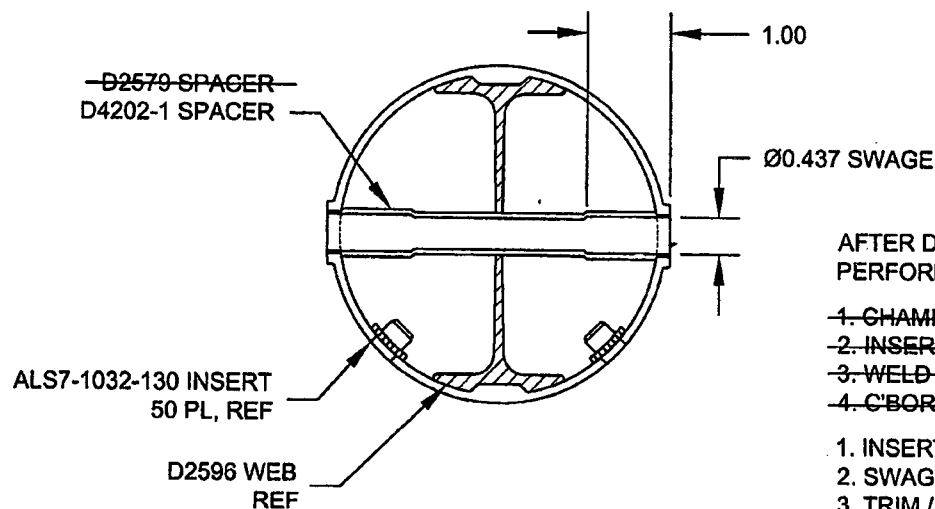
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
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SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries